

Date:

Use:

Wednesday, 1/30/2008 7:57:07 AM
Kim Johnston

Process Sheet

Split 08-03-05

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 37082 -2
Estimate Number : 10439
P.O. Number :
This Issue : 1/30/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : LARGE FAB ASSY
Previous Run : 35440
Written By :
Checked & Approved By :
Comment : Est: C 05.05.26 Added D3158-050 KJ/JLM

Drawing Name : HANDLE ASSEMBLY

Part Number : D3331041
Drawing Number : D3331 REV. C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 2/11/2008

Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M1025TR0875W125 1025 Round Steel Bar



Comment: Qty.: 1.5000 f(s)/Unit Total: 30.0000 f(s)
1025 Round Steel Bar
Material: AISI 1010-1025 Ø0.875" tubing, 0.125" wall
(M1025TR0.875W.125) Batch: M107021 J.F. 08/02/11

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1- Cut handle to finish length as per Dwg D3331
2- Form as per Dwg D3331 using DT8760 crimping Jig

3.0 LATHE CONV. CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE
Turn as per Dwg D3331
Identify as D3331-1

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY

Job Number: 37082

Part Number: D3331041

Job Number:



Seq. #: Machine Or Operation: Description:

6.0 238032 3/16" Dowel Pin 1" long



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
3/16" Dowel Pin 1" long

Pick:

Qty	Part Number	Description	Batch
1	238-032	3/16"-1" long Dowel	84106162

08/03/05 1x

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1- Deburr
2- Drill dowel hole as per Dwg D3331
3- Insert and Weld dowel as per Dwg D3331

Qty	Part Number	Description	Batch
A/R	N/A	Steel Rod	4105138

08/03/05 1x

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/03/05

08/03/05 1x

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat Fire Red (Ref. 4.3.5.10) as per QSI 005 4.3

M18052

08/03/05 1x

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08/03/05 1x

11.0 GP78R Black Vinyl Grid



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
Black Vinyl Grid

Pick:

Qty	Part Number	Description	Batch
1	GP-78R	Black Vinyl Grid	M107136

08/03/05 1x

12.0 D3158 Heat Shrink



Comment: Qty.: 0.4166 f(s)/Unit Total: 8.3320 f(s)
Heat Shrink

Pick:

08/03/05

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY

Job Number: 37082

Part Number: D3331041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty Part Number Description
5" D3158 Heat Shrink

Batch

B 24615

1x

JS 08/03/06

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Assemble as per Dwg D3331
Identify as D3331-041

JS 08/03/06

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/03/06

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: (STEVE)

JS 08/03/06

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

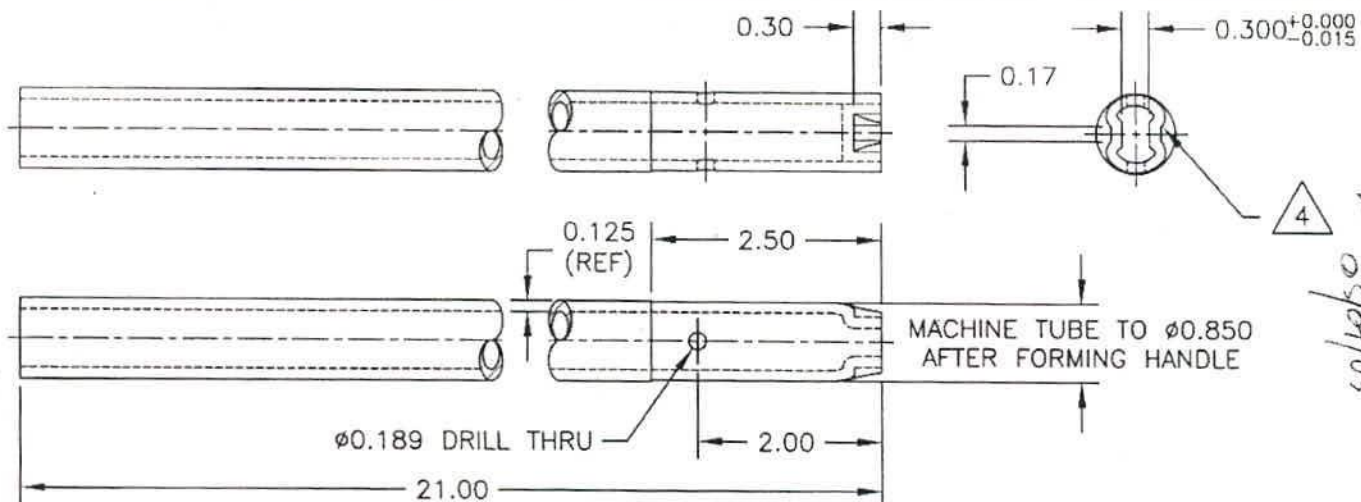
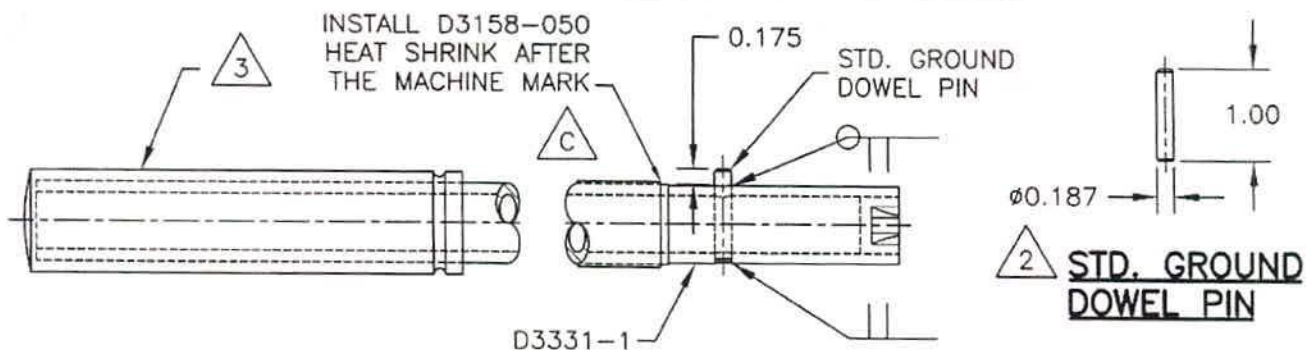
JS 08/03/07

Job Completion



2008/3/07

(1)

DARTRELEASED
05/07/05**1 D3331-1 HANDLE****D3331-041 HANDLE ASS'Y****NOTES:**

- 1) MATERIAL: 1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR0.875W.125)
- 2) STD. GROUND DOWEL PIN, $\phi 3/16$ " x 1.00" LONG
POSSIBLE SUPPLIER: SPAENAU, P/N 238-032
- 3) STD. BLACK VINYL GRIP, 7/8" I.D. x 4 3/4" LONG
POSSIBLE SUPPLIER: REID TOOL SUPPLY CO., P/N GP-78R
- 4) FORM USING TOOLING DT8760
- 5) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 37082

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
CHECKED	APPROVED	D3331	SHEET 1 OF 1
DATE		TITLE	SCALE
05.05.20		HANDLE WELDMENT	1:2
A	04.11.29	NEW ISSUE	
B	05.02.18	LENGTH 21.00 WAS 18.00	
C	05.05.20	ADD D3158-050	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries